

Work Order ID 80126

February-10-12 11:24:57 AM

80126

Page 1

Item ID: D4354-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw Wearplate Assembly

Start Date: 10/02/2012 Start Qty: 4.00

4

Required Date: 24/02/2012 Req'd Qty: 4.00

4

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: M.C.S.

Date: 12/02/10

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4354

b

0.00

100

100

Waterjet

0.00

FLOW CNC Waterjet

Memo

1-Cut as per Dwg. (D4354-1)

Dwg Rev: 1

Prog Rev: 1

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

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Item ID: D4354-041
 Revision ID:
 Item Name: Bearpaw Wearplate Assembly
 Start Date: 10/02/2012 Start Qty: 4.00
 Required Date: 24/02/2012 Req'd Qty: 4.00
 Reference:

Accept

N9000040100

Setup Start *NS1*
 Stop *NS2*

Cust Item ID:
 Customer:

Approvals: Process Plan: Date: Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Large Fab

Memo

0.00

Large Fab

1- Weld cups as per dwg
 A/R S.S. ROD BAT M/20013
 2- Apply hardfacing on wearplate as indicated on dwg
 A/R HARDCOAT 2059B BATCH M/20645

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

Quality Control

(2)

12-02-22 JBL

8/26/27

(x2)

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Item ID: D4354-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw Wearplate Assembly

Start Date: 10/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 24/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location *254*

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

Pl 12-02-27 2X

12/02/29

MLJ 12/02/29

12/02-29

Picklist Print

February-10-12 11:25:02 AM

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Work Order ID: 80126

80126

Parent Item: D4354-041

D4354-041

Parent Item Name: Bearpaw Wearplate Assembly

Start Date: 10/02/2012

Required Date: 24/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERIFIED

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

58.0000

0.9223

3.883368

M304S16GA

**

304/316 Sheet .063

W 12 12 12

Location

Loc Qty

Loc Code

MAT020

58

119653

58

D4379-1

Manufactured

No

130

Each

57.0000

10

40

D4379-1

**

Wearplate Cup

Location

Loc Qty

Loc Code

WA035

57

72388

57

79649 X 7

12-02-22 JBL

ITEM	QTY	P/N	DESCRIPTION
	X	D4354-041	429 BEARPAW WEARPLATE ASSEMBLY
1	1	D4354-1	429 BEARPAW WEARPLATE
2	10	D4379-1	WEARPLATE CUP
3	A/R	2059B	HARDCOAT

D4354-041 429 BEARPAW WEARPLATE ASSEMBLY

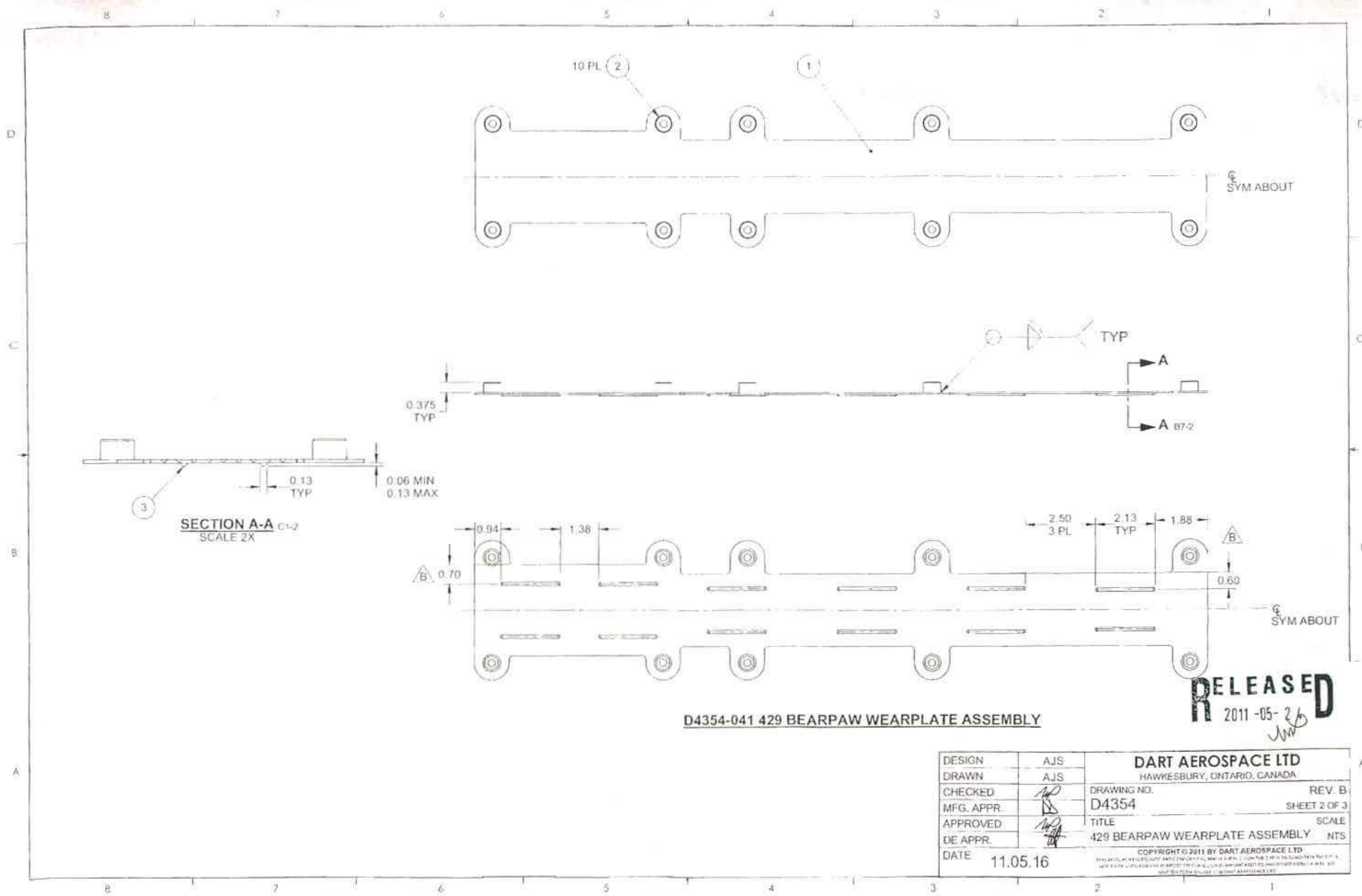
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4354-041" AND B/N "BXXXXX" PER DART OSI 044 G. 1 (FINE POINT MARKER)
- 7) WEIGHT: 1.76 lbs
- 8) WELDING: PER OSI 004
- 9) 2059B HARDCOAT WELD, 12 PL

RELEASED
2011-05-26

DESIGN	AJS	DESCRIPTION	AJS	11/1
DRAWN	AJS	NEW ISSUE	AJS	11/1
CHECKED			BY	D/
MFG APPR				
APPROVED				
DE APPR				
DATE	11.05.16			
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4354 TITLE 429 BEARPAW WEARPLATE ASSEMBLY SHEET F COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED HEREIN. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.				

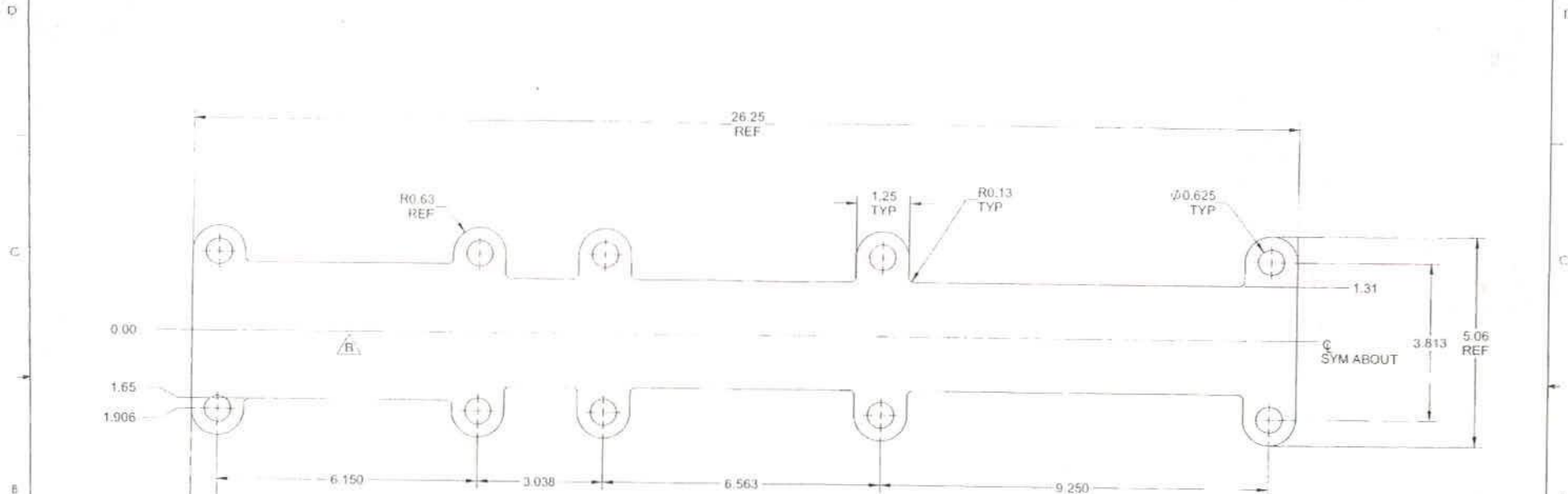
801210



D4354-041 429 BEARPAW WEARPLATE ASSEMBLY

RELEASED
2011-05-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4354	SHEET 2 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	429 BEARPAW WEARPLATE ASSEMBLY	NTS
DATE	11.05.16	COPYRIGHT © 2011 BY DART AEROSPACE LTD.	



D4354-1 429 BEARPAW WEARPLATE

RELEASE
2011-05-24

NOTES:

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.52 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>160</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>160</i>	D4354	SHEET 3 OF 3
APPROVED	<i>160</i>	TITLE	SCALE
DE APPR.	<i>160</i>	429 BEARPAW WEARPLATE ASSEMBLY	NTS
DATE	11.05.16	COPYRIGHT © 2011 BY DART AEROSPACE LTD It is acknowledged that this drawing is the property of DART AEROSPACE LTD and it is not to be used for any other purpose without the written consent of DART AEROSPACE LTD.	

DART AEROSPACE LTD

Work Order: 80126

Description: *Engine complete key*

Part Number: 753Y-001

Inspection Dwg: 753Y Rev: 2

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FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.675	± 0.010	2.675	—		Probe 0.002	2.675
0.600	± 0.010	0.600	—		Probe 0.002	
5.00	± 0.010	5.00	—		"	
3.875	± 0.010	3.875	—		"	
6.150	± 0.010	6.15	—		"	
7.033	± 0.010	7.032	—		"	
6.565	± 0.010	6.557	—		"	
9.250	± 0.010	9.248	—		"	
1.675	± 0.010	1.676	—		"	
1.700	± 0.010	1.701	—		"	
1.25	± 0.010	1.25	—		"	

Measured by: *R*Audited by: *W*

Prototype Approval:

Date: 12/1/87

Date: 12/1/87

Date:

Rev

Date

Change

5

Revised by

Approved

A

New Issue

KJULM

